

# Work Order ID 64972

Wednesday, January 05, 2011 11:25:53 AM



Page 1

Item ID:	D2432	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	206 (24") Bearpaw					
Start Date:	1/5/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	1/14/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-01-11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2432	Rev F3								

120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File								

B11-1-5

(2)

130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr								

aml 11/01/11

2

140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

aml 11/01/11

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64972**

Wednesday, January 05, 2011 11:25:53 AM

Page 2

Item ID: D2432

Accept

Revision ID:

Item Name: 206 (24") Bearpaw

Start Date: 1/5/2011 Start Qty: 2.00

Required Date: 1/14/2011 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

151

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control



②

11/01/11 ②

11/01/18

MF

11-01-18

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, January 05, 2011 11:25:57 AM

Page 1

Work Order ID: 64972

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw





Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 2.00

Required Qty: 2.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			120	sf	80.5794	3.7	7.4			
UHMW 1" Black													

1811-1-5

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	80.5794	
114624	5.2734	
115325	15.506	
115955	38.8	
116281	21	

116281

2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<i>64972</i>
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2432
<b>Inspection Dwg:</b> D2432 <b>Rev:</b> F3		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                 
 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	<i>0.063 x 45°</i>	<i>✓</i>		<i>Vern</i>	<i>ML-7</i>
B	5.500	+/-0.030	<i>5.504</i>	<i>✓</i>		<i>"</i>	<i>"</i>
C	0.200	+/-0.030	<i>.195</i>	<i>✓</i>		<i>"</i>	<i>"</i>
D	0.25 x 45°	+/-0.030	<i>.240 x 45°</i>	<i>✓</i>		<i>"</i>	<i>"</i>
E	R0.250	+/-0.030	<i>R.250</i>	<i>✓</i>		<i>Rad-yeal</i>	<i>REF</i>
F	0.250	+/-0.010	<i>.247</i>	<i>✓</i>		<i>Vern</i>	<i>ML-7</i>
G	0.625	+/-0.030	<i>.615</i>	<i>✓</i>		<i>"</i>	<i>"</i>
H	0.375	+/-0.010	<i>.381</i>	<i>✓</i>		<i>"</i>	<i>"</i>
I	0.950	+0.030/0.010	<i>.950</i>	<i>✓</i>		<i>"</i>	<i>"</i>
J	19.000	+/-0.030	<i>19.000</i>	<i>✓</i>		<i>M-type</i>	<i>ML-2</i>
K	3.14	+/-0.030	<i>3.120</i>	<i>✓</i>		<i>Vern</i>	<i>ML-7</i>
L	3.28	+/-0.030	<i>3.300</i>	<i>✓</i>		<i>"</i>	<i>"</i>
M	Ø0.260	+0.005/-0.000	<i>Ø.260</i>	<i>✓</i>		<i>"</i>	<i>"</i>
N	Ø0.93	+/-0.030	<i>Ø.927</i>	<i>✓</i>		<i>"</i>	<i>"</i>
O	0.30	+0.030/-0.000	<i>.320</i>	<i>✓</i>		<i>"</i>	<i>"</i>
P	23.750	+/-0.030	<i>23.750</i>	<i>✓</i>		<i>M-type</i>	<i>ML-2</i>
Q	7.375	+/-0.030	<i>7.375</i>	<i>✓</i>		<i>"</i>	<i>"</i>
R	4.250	+/-0.010	<i>4.250</i>	<i>✓</i>		<i>"</i>	<i>"</i>
S	2.000	+/-0.030	<i>2.000</i>	<i>✓</i>		<i>"</i>	<i>"</i>
T	9.000	+/-0.010	<i>9.000</i>	<i>✓</i>		<i>"</i>	<i>"</i>
U	9.000	+/-0.010	<i>9.000</i>	<i>✓</i>		<i>"</i>	<i>"</i>
V	0.375	+/-0.010	<i>.378</i>	<i>✓</i>		<i>Vern</i>	<i>ML-7</i>

<b>Measured by:</b>	<i>[Signature]</i>	<b>Audited by:</b>	<i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	<i>10/01/11</i>	<b>Date:</b>	<i>11/01/11</i>	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue      P/O K10008/D206-559-015	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



F1	99.03.03	ADD DEO 9143
F2	01.03.28	<del>Ø0.93 WAS Ø0.75</del> RF
F3	02.01.23	CLARIFY CORE DIMS RF

**RELEASED**  
43.06.17 KE

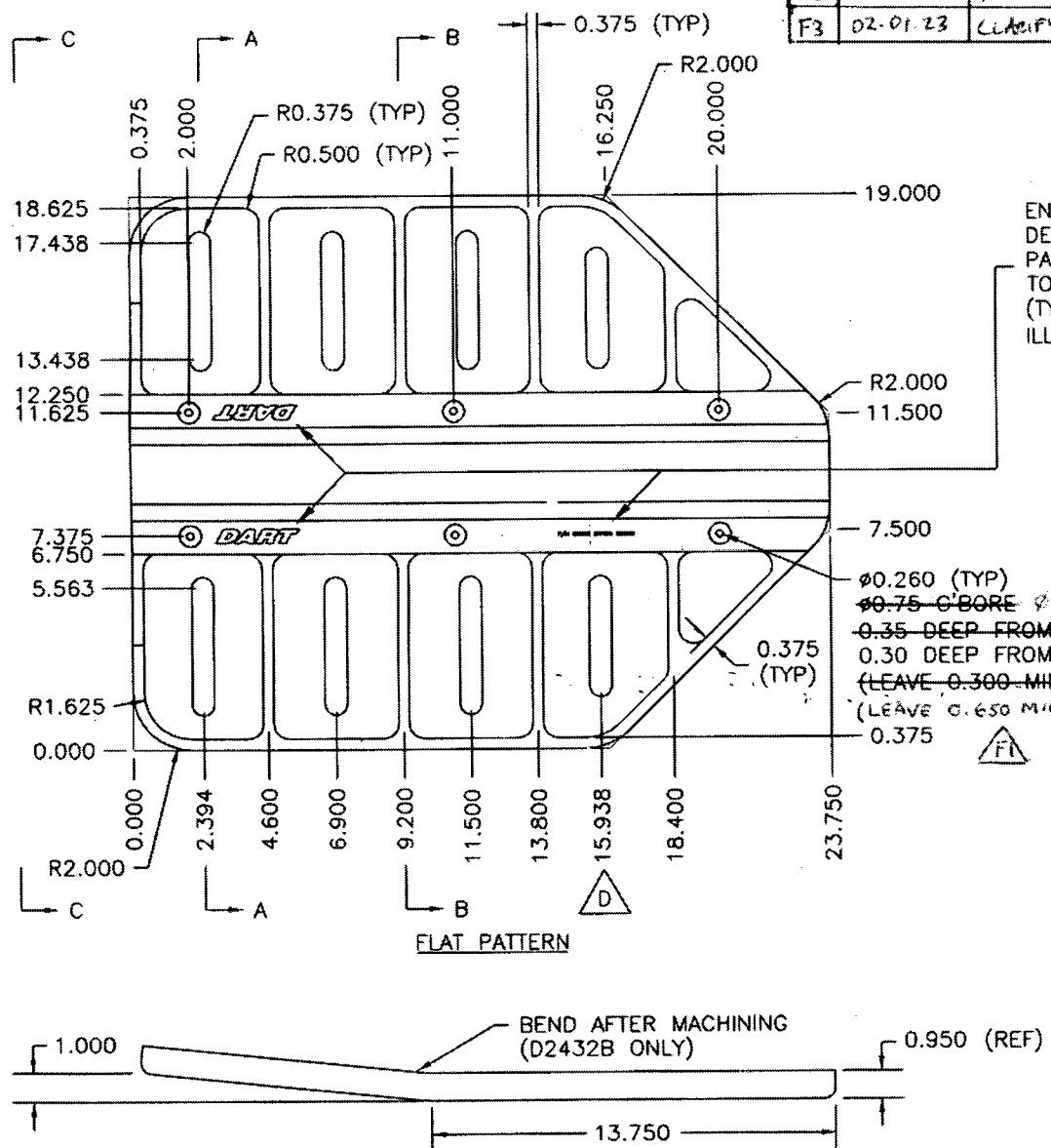
COPY  
SENT TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *14002*  
*2/11-01-5*



ENGRAVE LOGO TO MAX  
DEPTH OF 0.012. ENGRAVE  
PART AND BATCH NUMBERS  
TO MAX DEPTH OF 0.010.  
(TYPICAL LOCATION AS  
ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
<i>MM</i>	<i>JS</i>	D2432
DATE	TITLE	REV. F
98.05.12	BEARPAW	SHEET 1 OF 2
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

EFFECTIVE	DEOS
9143	



D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
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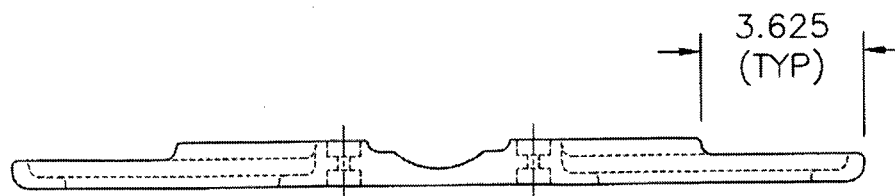
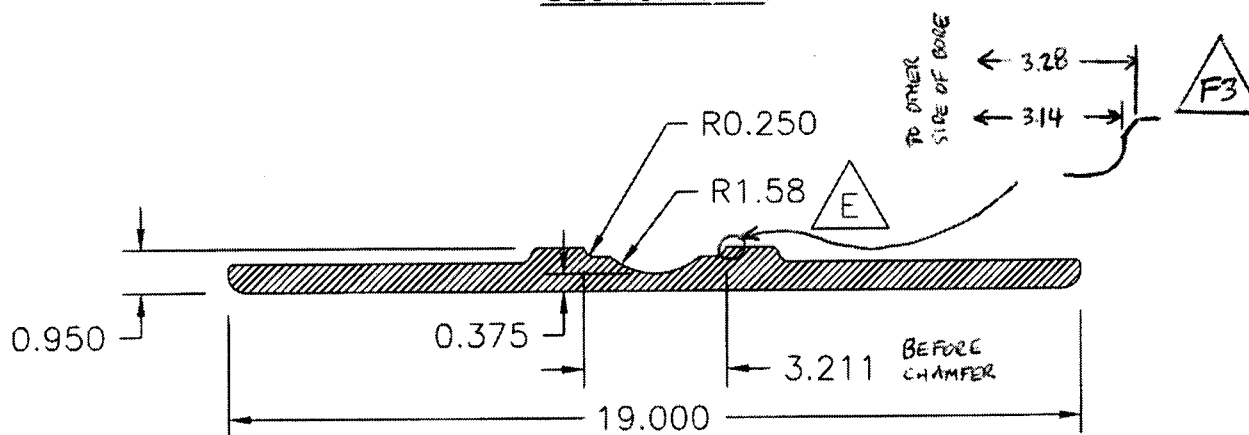
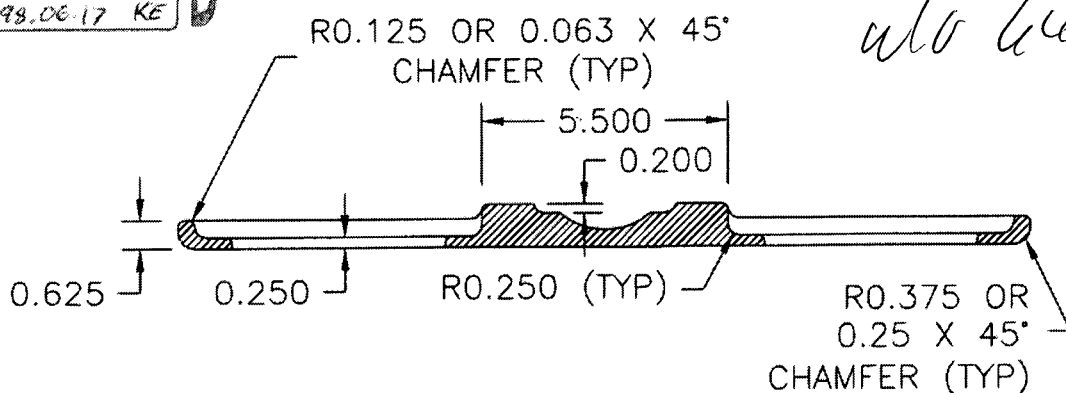
**NOTE:** Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED  
98.06.17 KE

u/o 44972



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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